

Work Order ID 64098

Wednesday, November 24, 2010 8:56:01 AM

Page 1

Item ID: D2364

Accept

Setup Start

Revision ID:

Stop

Item Name: Deck Plate, Fwd 350 Litt

Start Date: 11/24/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-24

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2364

Rev F

100

0.00

MAT NOT PULLED



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2364

☐ Dwg Rev: F

☐ Prog Rev: F

☐ 2-

Deburr if necessary

10-11-29

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-11-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/11/29

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- counter sink holes as per dwg D2364-2- deburr if necessary

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

EP 10/11/30 (6)

(X)

= 7 10/11/30

X6

X

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Page 3

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Item Name: Deck Plate, Fwd 350 Litt

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Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per OSI005 4.3

0.00

M 112588

Memo

0.00

START TIME:

11:45

OVEN TEMPERATURE:

320 FINISH TIME:

12:15

6 BR 10-11-30

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> M 10/11/30

Memo

0.00

6 8

180



Packaging

Packaging

Identify as per dwg & Stock Location: *925*

0.00

Memo

0.00

10/11/30 sl 60

W/O:		WORK ORDER CHANGES					
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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/01.20

U 10-11-30

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:56:05 AM

Page 1

Work Order ID: 64098

Parent Item: D2364

Parent Item Name: Deck Plate, Fwd 350 Litt



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. E□00.06.26□Removed P/O for powder coat□EC□
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

sf

199.5900

1



6061-T6 .050 Sheet



B10-11-29

in comb.

Location

Loc Qty

Loc Code

MAT

166.8

114799

38.8

114993

128

MAT21

32.79

110791

1.2

113216

31.59

(6)

Pto →

8 10/11/11

2074 .063

AS PER DRAWING

113866

113866

Dart Aerospace Ltd

W/O: 64098		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
White	#100	Perm. change update matl. to 2004 T3 .063" thick as per Day. Fix w/o + Bom. ADD copy of new bom for Ref.					S 10/1/09	
		In Intuitive It was already done long time ago. 2009 last mod date 10.12.01						

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	U4098
Description: Litter Deck Plate Kit (350)		Part Number:	D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.628	X		✓ BOZ	
Ø0.171	+0.005/-0.000	.173	X		✓	
0.354	+/-0.010	.352	X		✓	
11.242	+/-0.010	11.244	X		✓ PRO BOZ	
3.031	+/-0.010	3.032	X		✓	
1.903	+/-0.010	1.907	X		✓	
1.128	+/-0.010	1.128	X		✓	
0.354	+/-0.010	.354	X		✓	
1.340	+/-0.005	1.334	X		✓	
2.326	+/-0.010	2.321	X		✓	
3.312	+/-0.010	3.312	X		✓	
4.298	+/-0.010	4.298	X		✓	
5.284	+/-0.010	5.283	X		✓	
6.151	+/-0.010	6.150	X		✓	
6.270	+/-0.010	6.270	X		✓	
0.354	+/-0.010	.356	X		✓	
3.031	+/-0.010	3.032	X		✓	
Ø0.656	+0.005/-0.000	.656	X		✓	
5.003	+/-0.010	5.005	X		✓	
4.605	+/-0.010	4.603	X		✓	
1.776	+/-0.010	1.779	X		✓	
0.980	+/-0.010	.981	X		✓	
4.487	+/-0.010	4.490	X		✓	
7.192	+/-0.010	7.195	X		✓	
7.567	+/-0.010	7.570	X		✓	
7.942	+/-0.010	7.947	X		✓	
Ø0.191	+0.005/-0.000	.191	X		✓	
Ø0.197	+0.005/-0.000	.194	X		✓	
11.145	+/-0.010	11.148	X		✓ PRO BOZ	
12.181	+/-0.010	12.183	X		✓ PRO	
11.378	+/-0.010	11.383	X		✓ PRO	
11.776	+/-0.010	11.777	X		✓ PRO	
12.173	+/-0.010	12.175	X		✓ PRO	
4.690	+/-0.010	4.693	X		✓	
Ø0.250	+0.005/-0.000	.252	X		✓	
3.141	+/-0.010	3.148	X		✓	
Ø0.171	+0.005/-0.000	.173	X		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-11-29	Date: 10/11/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

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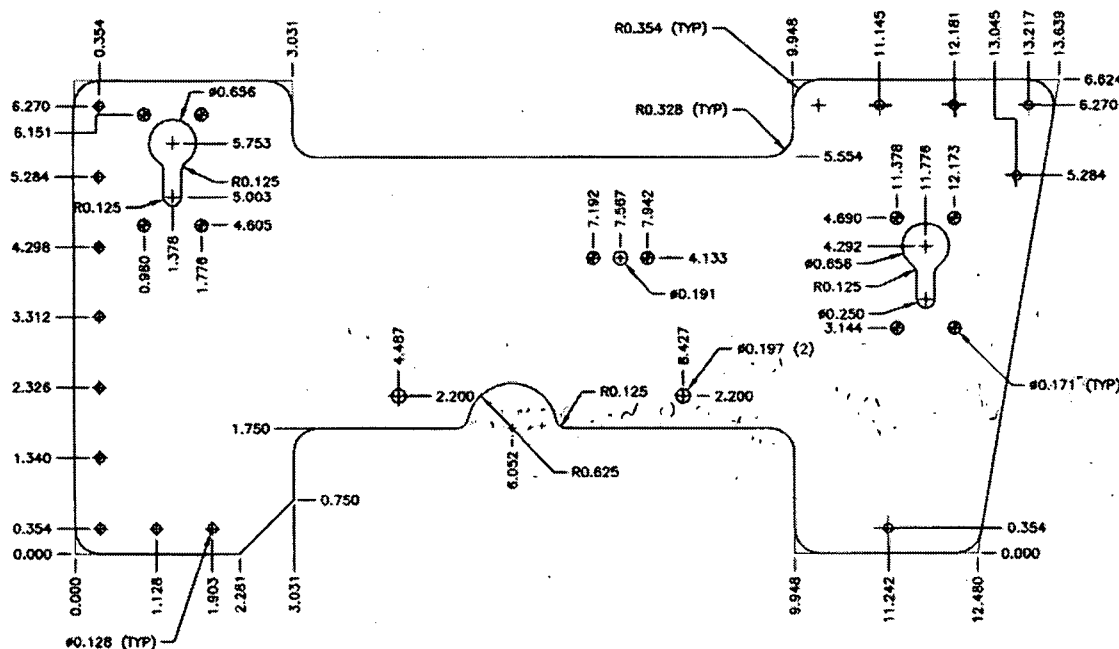
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **44096**
2/10/1-24



RELEASED
43/06/22 KE

- COUNTER SINK HOLES:
 ◆ C SINK $\varnothing 0.225 \times 100^\circ$ (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)
 ● C SINK $\varnothing 0.308 \times 100^\circ$



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
 FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2364	SHEET 1 OF 1
DATE 98.06.19	TITLE LITTER DECK PLATE, 350	SCALE 2:5	
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEYWAY	
D	95.03.06	0.191 WAS 0.197	
E	95.10.06	GEOMETRY CHANGES	
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	

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